



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-213
Job Sheet 170882



Part No: D119-646-213

Job Qty: 1 ea

Part Name: AW119 Skidtube with Heavy Duty Wearplates, Float Compatible - LH



Part Weight: 0 lbs

Status: Scheduled

Priority: AOG

Job Created: 1/23/18

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: AOG

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.12 as per ECN12-644 DD verf:JLM IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to chg004 (ECN 13-534) DD verf:JLM IPP REV:E 14.11.25 chg004 (ECN 14-628) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/31/18	1/31/18	0.00	0.00	Start Up Stores/Pkg-1		JAN 31 2018 W.K.
110	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs	1/31/18	1/31/18	0.00	0.00	QC4		
125	DC	1 pcs	1/31/18	1/31/18	0.00	0.00	DC		
130	Packaging	1 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	1/31/18	1/31/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP D119-646-213 CHG 006

Descriptions: 130 - Identify and pack for shipping as per PPP D119-642-213 Location: Fgo74 PPP rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C50A	Bolt	8 Ea (8 ea)	90-Start up Operation	
AN4C6A	Bolt	12 Ea (12 ea)	90-Start up Operation	
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	
D119-646-311	Ground Handling	1 Ea (1 ea)	90-Start up Operation	
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	
D2712	Set Screw	12 Ea (12 ea)	90-Start up Operation	
D3407-041	Tow Ring	1 Ea (1 ea)	90-Start up Operation	
D3417-5	Washer	2 Ea (2 ea)	90-Start up Operation	
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	
D3672-3	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation	
D3672-7	Washer, Phenolic	24 Ea (24 ea)	90-Start up	
D3883-1	Saddle, Outboard LH			



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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____		

DART
AEROSPACE
S037637

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CANADA
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**AW119 Skidtube with Heavy Duty Wearplates, Float
Compatible – LH**

PART NO: D119-646-213

Original Serial #: S037637

Revision:

Operation: QC
Change No: CHG006

Mfg Date: 01/31/18

Job No: 170882

Root Cause	
Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pre	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐

Poor Information

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

OTHER :

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Finish

Misread

Turning Sequence

Start up Operation
Job No: 170882
Serial #: S037637
D119-646-213
Tube with Heavy Duty Wearplate
CHG006
637
ROSPACE

D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	
MS21043-3	Nut	8 Ea (8 ea)	90-Start up Operation	
MS21043-4	Nut	13 Ea (13 ea)	90-Start up Operation	
MS21250-05-006	Bolt	8 Ea (8 ea)	90-Start up Operation	
NAS1149C0332R	Washer	8 Ea (8 ea)	90-Start up Operation	
NAS1149C0432R	Washer	24 Ea (24 ea)	90-Start up Operation	
NAS1149C0532R	Washer	8 Ea (8 ea)	90-Start up Operation	
Part Specifications				
Specifications could not be found.				

Plex 1/23/18 11:38 AM dart.poulin.mario

DCA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																			
	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																			
	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																			
Large Fab ☐	Composite ☐	Supplier ☐																					

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					



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Master Unit 000327

Containers on Master Unit 000327				
Serial No	Part No	Customer Part No	Status	Quantity
S037585	AN3C50A		Allocated	8
S037582	AN4C6A		Allocated	12
S037579	D2652	D2652	Allocated	16
S037578	D2712	D2712	Allocated	12
S037577	D3407-041		Allocated	1
S037576	D3417-5	D3417-5	Allocated	2
S037574	D3456-1	D3456-1	Allocated	1
S037572	D3672-3	D3672-3	Allocated	24
S037571	D3672-7		Allocated	24
S026468	D3883-1		Allocated	2
S025206	D3884-1		Allocated	2
S037569	MS21043-3	MS21043-3	Allocated	8
S037568	MS21043-4	MS21043-4	Allocated	13
S037567	MS21250-05-006		Allocated	8
S037565	NAS1149C0332R		Allocated	8
S037563	NAS1149C0432R		Allocated	24
S037573	NAS1149C0532R		Allocated	8

D119-646-311

D119-646-243

S037446

B129394